

Date: Tuesday, 4/25/2006 1:55:21 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 350 SKIDTUBE ASSEMBLY RH
 Job Number : 26837
 Estimate Number : 10268
 P.O. Number : N/A Part Number : D350636014
 This Issue : 4/25/2006 S.O. No. : N/A Drawing Number : D2750 REV D
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : LANDING GEAR Drawing Revision : D
 Previous Run : 26104 Material : N/A
 Written By : SEE COMMENT BELOW Due Date : 5/20/2006 Qty: 1 Um: Each
 Checked & Approved By : 06.04.25
 Comment : Est Rev:H 02.09.25 Rearranged procedure steps KJ
 Est Rev:I 05.12.08 Rearranged procedure steps EC
 Est Rev:J 06.03.30 Per rev. D EC

RETURN 499
 SCRAPED

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	DC	DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy blue file and type labels per PPP D350-636-014 CHG 002

KJ 06.05.10

(7)

2.0

D26003BENT

Extrusion Bent



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1- D2600-3-Bent

Extrusion (Bent)

B26787

DPOG-52

3.0

D2744

Fwd Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Cap

Batch: 24672 BE 06-05-03

4.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1- Mark cut line on aft end of D2600-3-Bent using Jig DT 8150. Cut to length as per Dwg D2750. Deburr end

2-Drill pilot holes as per Dwg D2750 sheet 3 (D2750-1 details).Drill using drill Jig DT8150 & DT8864 drilling holes labelled "B" only.

3- Mark fwd end for cutting using Drill Jig DT 8150 & DT8864 and cut as per dwg D2750.

DD
 06-5-2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Part Number: D350636014

Job Number:



Seq. #:

Machine Or Operation:

Description :

4-Drill pilot holes for Detail B using DT8330

5-Drill pilot holes for wearplates as per Dwg D2750 using DT8108 and open to 0.250" ***Make sure that wearplate holes are on bottom of tube*****

6-Open up holes of Detail A to 0.250" (total of 2 holes per side)

7- Countersink all fwd wearshoe holes (total of 19 holes per side) DO NOT C'SINK THE LAST AFT HOLES (total of 2 per side for blade fitting) as per dwg D2750.

8-Countersink Detail A as per dwg D2750.

9-Weld D2744 Cap as per Dwg D2750 and QSI 004. Fill grooves in bend left from bending as per QSI 004
A/R Aluminum Rod *MP101 BE 06-05-03 (1)*

10-Grind welds flush as per Dwg D2750 *BE 06-05-04 (1)*

5.0

QC59

WELD INSPECTION



Q65 # 06-05-09

PD 06-05-09



Comment: WELD INSPECTION

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Pm 06-05-18 (1)



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

DP 06-05-23

8.0

D2739

350 I Beam



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Web

Batch:

B26921 Pm 06-05-23 (1)

9.0

D34901

CROSS BOLT SPACER



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Crossbolt spacer

Batch:

B26307 BE 06-05-25 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Drawing Name: 350 SKIDTUBE ASSEMBLY RH

Job Number: 26837

Part Number: D350636014

Job Number:



Seq. #:

Machine Or Operation:

Description:

10.0

D34905

CROSS BOLT SPACER



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Crossbolt spacer

Batch: M26309 BE 06-05-25 (1)

11.0

D2743

Crossbolt Spacer



Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)

Crossbolt Spacer

Batch: B25838 BE 06-05-25 (1)

12.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Open up holes for Detail B, "hole size W" and blade fitting location holes to 0.500" (total of 9 holes per side) as per dwg D2750. *pm 06-05-23 (1)*

2-Open up holes "size X" (total of 4 holes per side) as per dwg D2750 *pm 06-05-23 (1)*

3-Open up holes of Detail V & Detail C to 0.625" (total of 8 holes per side) as per dwg D2750. *pm 06-05-23 (1)*

4-Chamfer holes of Detail V, Detail C, hole size "W" and "X" per dwg D2750 (welding instructions on sheet 5) *pm 06-05-23 (1)*

5-Deburr and blow out all chips from inside of tube *pm 06-05-23 (1)*

6-Bond web D2739 in place as per QSI 015

A/R

Sikaflex-291

batch:

M60901

exp. date:

06-11-01

pm 06-05-23 (1)

7- Weld spacers D3490-1, D3490-5 and D2743 as per dwg D2750 & QSI004

(welding instructions on sheet 5)

A/R

Aluminum Rod

batch:

M19101

BE 06-05-25 (1)

8-Grind welds flush as per Dwg D2750 *pm 06-05-23 (1)*

9-Spot face ground handling holes section J-J (total of 4 places per side) as per dwg D2750 *pm 06-05-23 (1)*

10-Deburr holes *pm 06-05-23 (1)*

W/O:		WORK ORDER CHANGES					
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Part Number: D350636014

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

QC5/9

WELD INSPECTION

QC 9 -> PD 06-05-26



Comment: Inspect weld and work to Step 20

06-05-30 (1)

14.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Gloss White (Ref. 4.3.5.1) as per Dart QSI 005 4.3

DL 06/05/30 0

15.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Inspect for foreign object per QSI 024

Q.m 06-05-31 (1)

16.0

D26483

Wearpad



Comment: Qty.: 5.0000 Each(s)/Unit Total: 5.0000 Each(s)

Wearpad

Batch: B24843-2

17.0

D265613

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Wearplate

Batch: B25914

18.0

D265635

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Wearplate

Batch: B26206

19.0

D2746

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Wearplate

Batch: B25841

DL 06/05/31 (1)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Job Number: 26837

Part Number: D350636014

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

D2745

Bushing



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Bushing

Batch: B24879

21.0

D3488042

BLADE FITTING ASSEMBLY, RH



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Blade Fitting, RH

Batch: 26839

22.0

D3492041

PLUG ASSEMBLY



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

PLUG ASSEMBLY

Batch: B26304

23.0

D3492045

PLUG ASSEMBLY



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

PLUG ASSEMBLY

Batch: B26206

24.0

AN835A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bolt

Batch: M14576

25.0

AN960JD816

1/2" washer, Alum



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

Batch: M6956

DL 06/05/31 ①

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prdd Mgr	Approval QC Inspector	
060601	23	D3492-045 plugs not installed upon customer approval. Customer is installing Apical float system; plugs will be discarded. See email				<i>U</i>	<i>[Signature]</i> 060601	
060601	24	AUB35A no longer being used upon Assy apart from the Acceptance (see-email) at step 33 remove from step 24 permanent change <i>[Signature]</i>				<i>Per 05.05.01 Per 05.05.01 04.7</i>	<i>[Signature]</i> 060601	

Part No: _____ PAR #: 1 Fault Category: _____ NCR: Yes ☒ No ☐ DQA: *[Signature]* Date: 06/06/01
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Drawing Name: 350 SKIDTUBE ASSEMBLY RH

Job Number: 26837

Part Number: D350636014

Job Number:



Seq. #:

Machine Or Operation:

Description :

26.0

MS21083N8

Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Nut

Batch: M19099

27.0

ALC41032225

NAS 133053KB166

Insert



Comment: Qty.: 42.0000 Each(s)/Unit Total: 42.0000 Each(s)

Insert

Batch: M100199

28.0

AN960JD10L

Washer



Comment: Qty.: 42.0000 Each(s)/Unit Total: 42.0000 Each(s)

washer

Batch: M18235

29.0

AN3C5A

Bolt



Comment: Qty.: 38.0000 Each(s)/Unit Total: 38.0000 Each(s)

Bolt

Batch: M100186

30.0

AN3C6A

BOLT



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Bolt

Batch: M19522

31.0

AN3C7A

BOLT



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

BOLT

Batch: M19522

32.0

AN6C44A

BOLT



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

BOLT

Batch: M19477 19514

DL 06/05/31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Job Number: 26837

Part Number: D350636014

Job Number:



Seq. #:

Machine Or Operation:

Description :

33.0 AN8095A *AN3-35A PH 05.05.01* BOLT



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

BOLT

Batch: *M18576*

34.0 AN960C10L washer



Comment: Qty.: ~~46.0000~~ Each(s)/Unit Total: ~~46.0000~~ Each(s)

washer

Batch: *M18822*

06-07-31

35.0 AN960C816L WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

WASHER

Batch: *M100186*

36.0 MS210436 NUT



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

NUT

Batch: *M19185*

37.0 MS21083C8 NUT



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

NUT

Batch: *M19185 M100186*

38.0 NAS1330S3KB166 INSERT



Comment: Qty.: 42.0000 Each(s)/Unit Total: 42.0000 Each(s)

INSERT

Batch: *M100199*

39.0 NAS1515H3L WASHER



Comment: Qty.: 46.0000 Each(s)/Unit Total: ~~46.0000~~ Each(s)

WASHER

Batch: *M100186*

DL 06/05/31 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Drawing Name: 350 SKIDTUBE ASSEMBLY RH

Job Number: 26837

Part Number: D350636014

Job Number:



Seq. #:

Machine Or Operation:

Description :

40.0

NAS1515H8L

WASHER



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)

WASHER

Batch: M100187

41.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Install inserts as per dwg D2750

2-Spray inside of tube with "LPS-3" batch: M100609

→ PTO

3-Install blade fitting D3488-041, wearshoes and ground handling hardware as per dwg D2750

3-Coat all exposed fasteners with "LPS Procyon" batch: M17168

42.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

43.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

44.0

D2741

Blade



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Blade

Batch: ~~B26004~~ B25938

45.0

AN960C816L

WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

Batch: M100186

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
06-05-31	41.1	Would like A QCS for Insert inspection. QCS inspected by 2 06-05-31 Please Add as A Step before proceeding, permanent change				<i>[Signature]</i> 06-05-01	<i>[Signature]</i> 06-05-31

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: *[Signature]* Date: 06/06/01
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Drawing Name: 350 SKIDTUBE ASSEMBLY RH

Job Number: 26837

Part Number: D350636014

Job Number:



Seq. #:

Machine Or Operation:

Description :

46.0

MS21083C8

NUT



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Nut

Batch: m100186 ✓

47.0

AN8C21A

BOLT



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Bolt

Batch: m100202 ✓

48.0

NAS1515H8L

WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

WASHER

Batch: m100187 ✓

C206/06/01

49.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

50.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Package as per PPP D350-636-014

REV D

C206/06/01 (1)

51.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

C206/06/01 (1)

Job Completion



48.1/2x D3493-1 ✓ WASHER

Batch: B26009

C206/06/01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>P44</i>	DRAWN BY <i>P44</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2750	REV. D SHEET 1 OF 5
DATE 06.01.05		TITLE 350 SKIDTUBE ASSEMBLY SCALE NTS	
A	98.04.16	NEW ISSUE	
B	98.09.01	CHANGE MS24694-S293 TO AN8-16A	
C	98.11.18	ADD D2750-3/D2750-4 INCORPORATE D2738 AND D2740	
D	06.01.05	ADD HOLES AND SPACERS FOR APICAL FLOATS INCORPORATE DEO 9133/9157	

RELEASED
06.02.07 *[Signature]*

Qty -041	Qty -042	Qty -043	Qty -044	Part Number	Description
X				D2750-041	SKIDTUBE ASSEMBLY, LH
	X			D2750-042	SKIDTUBE ASSEMBLY, RH
		X		D2750-043	SKIDTUBE ASSEMBLY, LH
			X	D2750-044	SKIDTUBE ASSEMBLY, RH
5	5	5	5	D2648-3	WEARPAD
1	1	1	1	D2656-13	WEARSHOE
1	1	1	1	D2656-35	WEARSHOE
1	1	1	1	D2746	WEARSHOE
1	1	1	1	D2739	WEB
1	1	1	1	D2741	BLADE
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
38	38	38	38	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN3C7A	BOLT
4	4	4	4	AN6C44A	BOLT
2	2	2	2	AN8C21A	BOLT
1	1	1	1	AN8C35A	BOLT
46	46	46	46	AN960C10L	WASHER
4	4	4	4	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
3	3	3	3	MS21083C8	NUT
42	42	42	42	NAS1330S3KB166	INSERT
46	46	46	46	NAS1515H3L	WASHER
12	12	12	12	NAS1515H8L	WASHER

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *26837*

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DESIGN PH	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED #	APPROVED #	DRAWING NO. D2750	REV. 0 SHEET 2 OF 5
DATE 06.01.05		TITLE 350 SKIDTUBE ASSEMBLY	SCALE NTS

RELEASED
06.02.07 #

GENERAL NOTES:

1. ALL DIMENSIONS ARE IN INCHES
2. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
3. MAKE FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
4. DAMAGE TOLERANCE ON BENDING:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 12 INCHES ABOVE THE GROUND. NO GOUGING IS ACCEPTABLE IN THE FLAT PORTION OF THE TUBE. GOUGES UP TO 0.020 ARE ACCEPTABLE IN THE BENT PORTION OF THE TUBE. TUBE O.D. SHOULD BE 3.150 ± 0.010 IN THE FLAT PORTION OF THE TUBE. TUBE O.D. SHOULD BE 3.15 ± 0.030 IN THE BENT PORTION OF THE TUBE.
5. ALL HOLES DRILLED ON CENTERLINES EXCEPT THOSE NOTED BY SECTIONS E-E, F-F, AND R-R.
6. WELDING TO BE DONE PER DART QSI 004.
7. FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
MINIMUM YIELD TENSILE STRENGTH = 35 ksi
MINIMUM ULTIMATE TENSILE STRENGTH = 38 ksi
8. FINISH:
ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
9. INSTALL NAS1330S3KB166 INSERTS AFTER FINISH AS INDICATED IN D2750-1/-2/-3/-4 WELDING DETAIL ON PAGE 4 AND 5. DRILL 'E' SIZE HOLES ($\emptyset 0.250$ - $\emptyset 0.257$) FOR WEARSHOE INSERTS. C'SINK $\emptyset 0.391 \times 100^\circ$ AND INSTALL INSERTS
10. D3488-041 (OR D3488-042) BLADE FITTING AND AN3-5A/AN3-7A WEARSHOE SCREWS TO BE INSTALLED USING SIKAFLEX-241 (OR EQUIVALENT) SEALANT.
11. SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
12. APPLY A LAYER OF SIKAFLEX -241/-291 ADHESIVE BETWEEN THE BOTTOM OF THE SKIDTUBE ASSEMBLY AND THE WEARPLATES

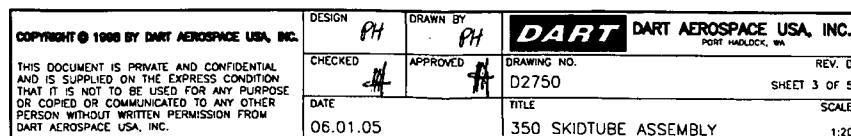
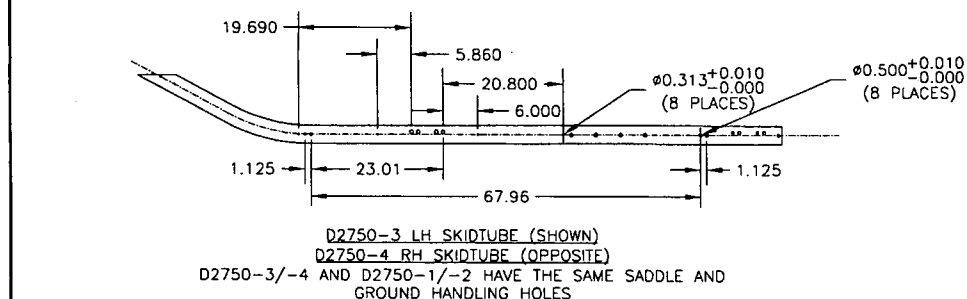
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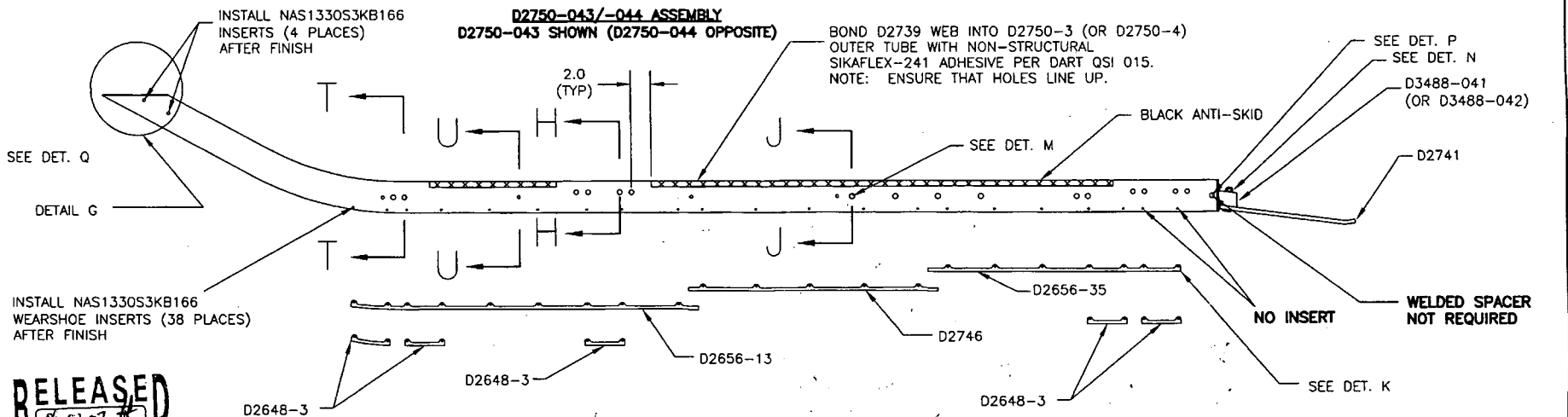
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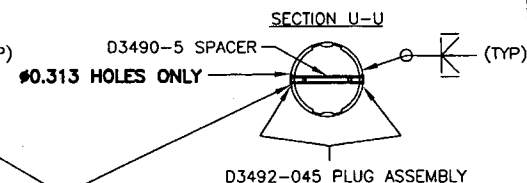
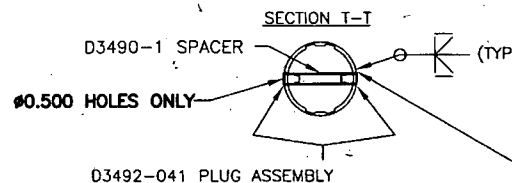
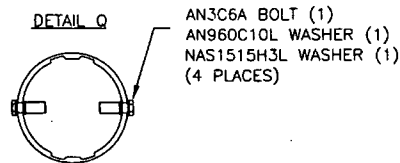
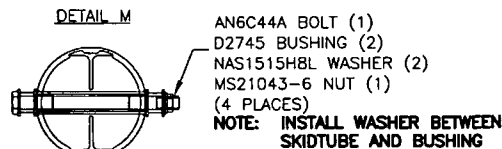
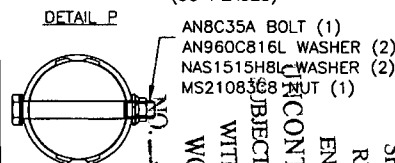
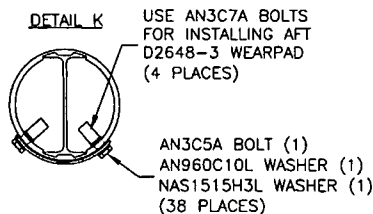
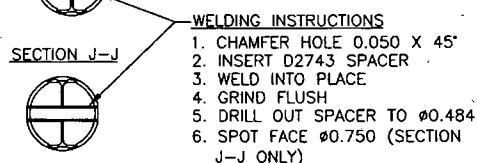
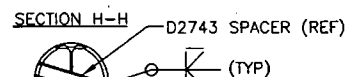
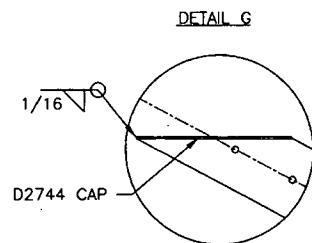
02.02.07 #



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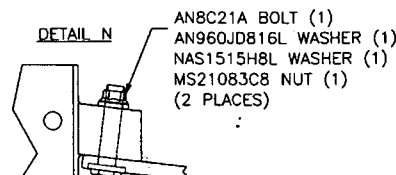


RELEASED
 06-02-07-11



WELDING INSTRUCTIONS

1. CHAMFER HOLE 0.050 X 45°
2. INSERT D3490-5 SPACER (4 PLACES) INTO Ø0.313 HOLES OR INSERT D3490-1 SPACER (4 PLACES) INTO Ø0.500 HOLES
3. WELD INTO PLACE
4. GRIND FLUSH
5. INSERT D3492-045 PLUG ASSEMBLY (8 PLACES) INTO D3490-5 SPACER OR INSERT D3492-041 PLUG ASSEMBLY (8 PLACES) INTO D3490-1 SPACER ON BOTH ENDS



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CHECKED	#	APPROVED	#	DRAWING NO.	D2750	REV. 0	SHEET 5 OF 5
DATE	06.01.05	TITLE	350 SKIDTUBE ASSEMBLY		SCALE	1:20	

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AEROSPACE LTD		Work Order: 26837
Description: 350 sub tube Assembly RH		Part Number: D350-636-014
Inspection Dwg: D2750 Rev: D		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

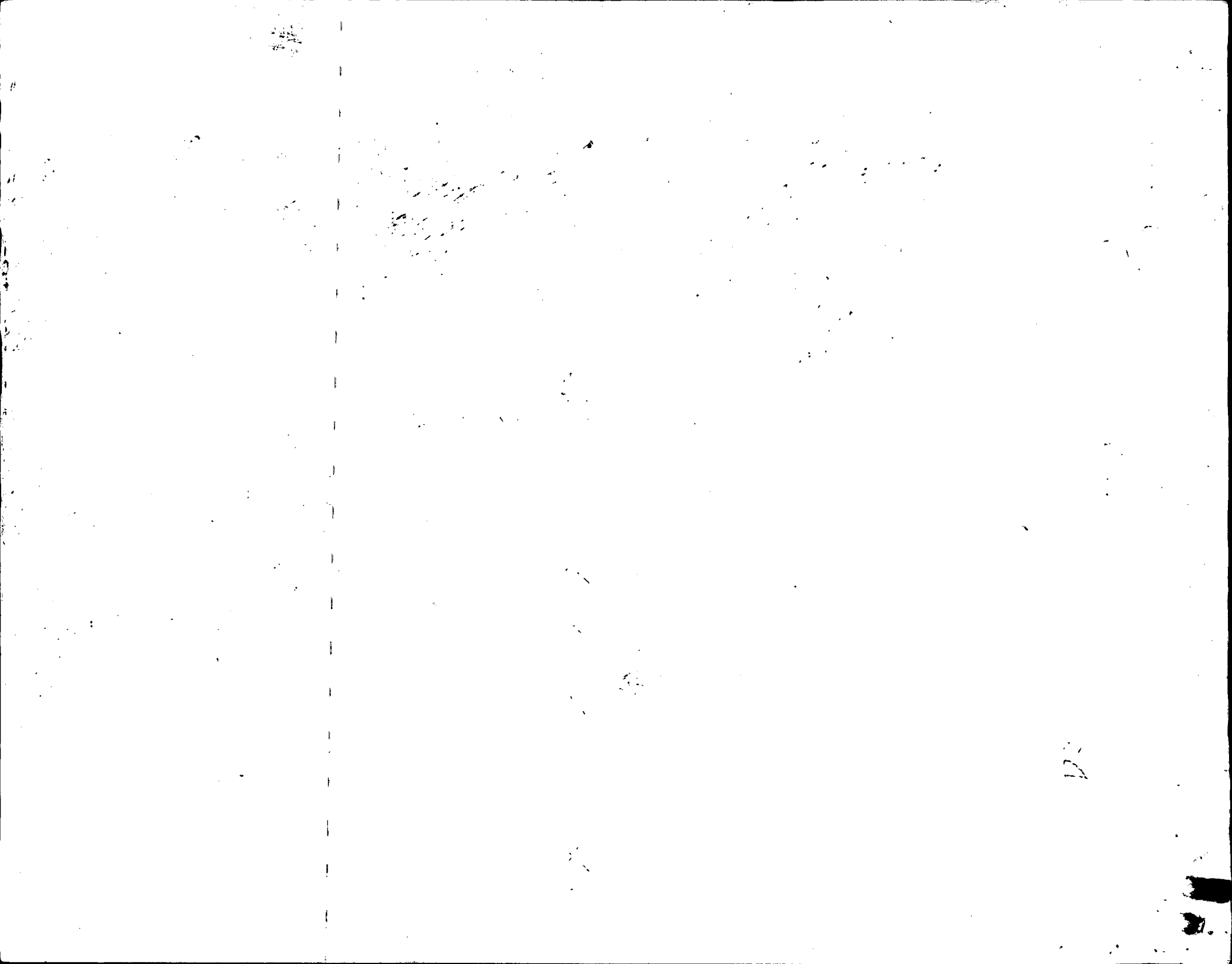
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Detail A						
0.83	.030	0.83				
2.720	.010	2.720				
Detail B						
1.180	.010	1.180				
3.150	.010	3.150				
1.180	.010	1.180				
Detail C						
1.180	.010	1.180				
3.150	.010	3.150				
1.180	.010	1.180				
Detail D						
1.720	.010	1.720				
3.940	.010	3.940				
1.720	.010	1.720				
.550	±.020	.550				
2.480	.010	2.480				
1.125	.010	1.125				
67.96	.010	67.96				
1.125	.010	1.125				
23.01	.030	23.01				

Doesn't apply to -014 or -013

All measurements verified *[Signature]*

Measured by: DP	Audited by: <i>[Signature]</i>	Prototype Approval: PH
Date: 06-5-2	Date: 06-05-30	Date: 06/05/30

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/RF	



C. FLOAT INSTALLATION

1. For MID floats to fit over skid tube, remove ground handling bolts from skid tube according to figure 6.
2. For FWD floats to fit over skid tube, remove bolts from skid tube according to fig 6. Fill thread with F/N 27 or Proseal 890 and install OEM cap.
3. Place float (F/N 1, 2, 3, 4, 5, and 6) on skid and locate per Figure 6. Match drill through the float girt with .190 drill. Remove the float and open holes to .318 - .328 diameter. Use Unibit #2 for ease of drilling. Dress holes and apply zinc chromate putty or Mastinox.

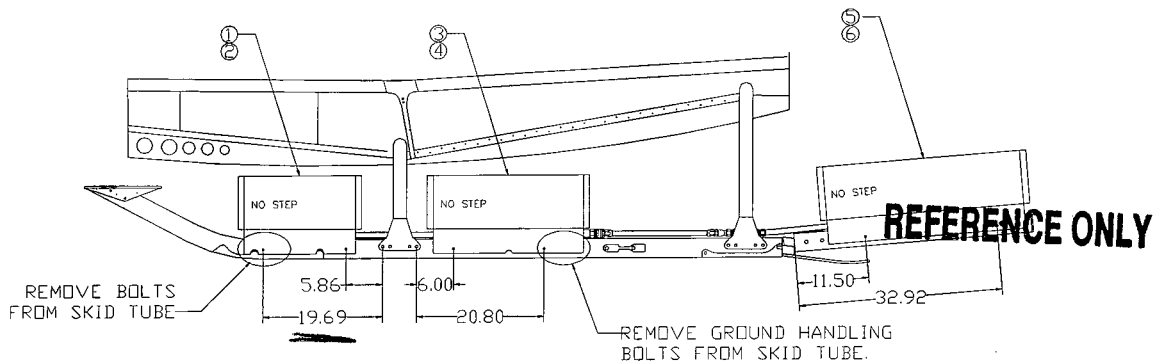
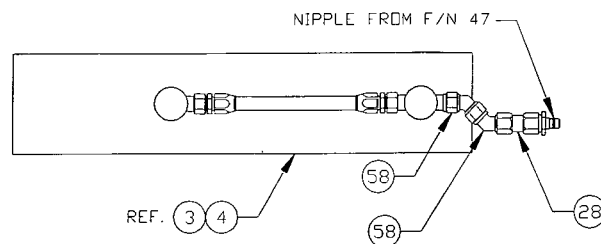


Figure 6.

4. Insert spacer (F/N 43 for fwd and mid floats and F/N 41 for aft floats) in holes drilled. See figure 8.
5. Connect hoses (F/N 55) to fwd floats.
6. Connect two 45° elbows (F/N 58) to each mid float (F/N 3 and 4). Connect union (F/N 28) to 45° elbow (F/N 58). Connect quick disconnect nipple from hose (F/N 47) to 45° elbow (F/N 58). See figure 7.

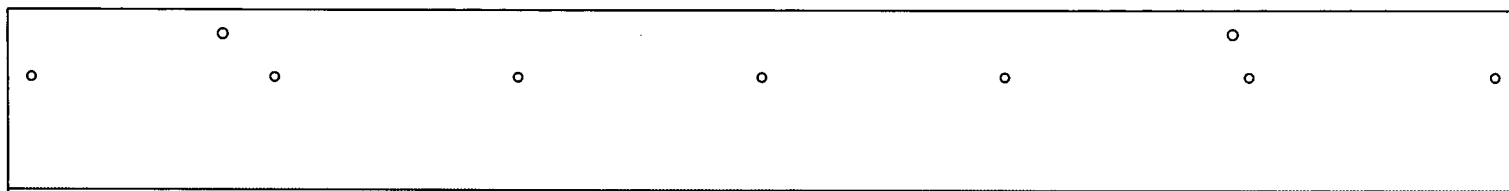
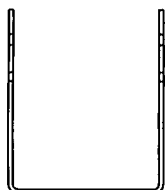


R.H. SHOWN FROM BOTTOM
L.H. OPPOSITE

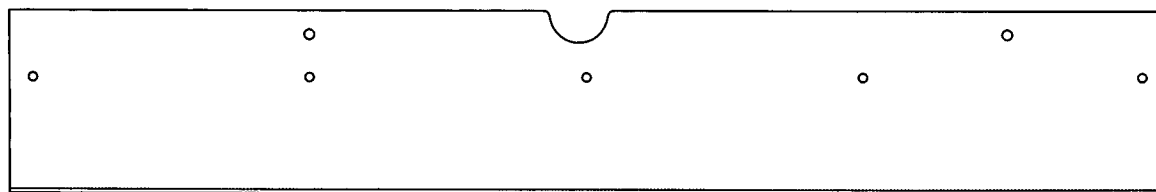
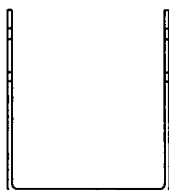
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TRI-BAG GIRTS

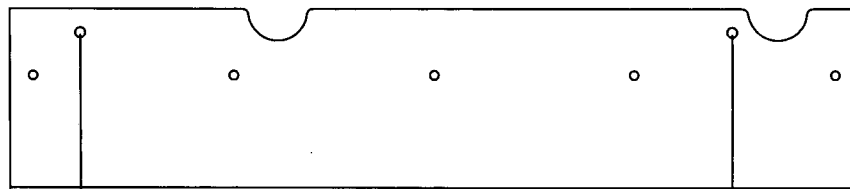
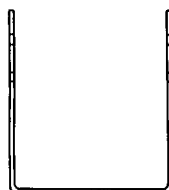
AFT FLOAT



MID FLOAT



FWD FLOAT



13.83

Peter Hum

From: David Shepherd [davids@dartaero.com]
Sent: Wednesday, May 31, 2006 4:13 PM
To: Peter Hum
Subject: Re: bolt securing aft blade fitting

Acceptable substitution.

----- Original Message -----

From: "Peter Hum" <phum@dartaero.com>
To: "David Shepherd (E-mail)" <davids@dartaero.com>
Cc: "Serge Shahbazian (E-mail)" <sshahbazian@dartaero.com>
Sent: Wednesday, May 31, 2006 2:06 PM
Subject: bolt securing aft blade fitting

> Hi David,
>
> The AN8C35A bolt (qty 1 per side) that is used on the D350-636-013/-014
skid
> is NOT available in stock/delivery.
>
> We placed an order for this part on Apr 1st and still haven't received
this
> part.
>
> If required would it be acceptable to use AN8-35A bolt as a replacement?
>
> Peter
>
>

Peter Hum

From: Peggy McDonald [pmcdonald@dartaero.com]
Sent: Thursday, June 01, 2006 10:26 AM
To: jmurdoch@dartaero.com
Cc: 'David Shepherd'; 'Peter Hum'; 'Bill Beckett'
Subject: APICAL FLOAT SKIDTUBES

Hi Jason,

In order not to delay this shipment of the APICAL float compatible skidtubes, the skidtubes were shipped without plugs in the holes that will be used for the Tri-Bag Float Install. I discussed this with Peter and David prior to contacting the customer. I advised the customer (Acro Heli-Pro) and they have accepted to receive these skidtubes as explained, due to a delivery deadline.

I hope this information is helpful. Contact me if you have any questions or concerns.

Peggy

6/1/2006